

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-021945**Date Inspected:** 07-Mar-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 1500**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 300**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** ShangHai, China**CWI Name:** Sha Zhi**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

Summary of Items Observed: On this date Caltrans OSM Quality Assurance(QA) Inspector, DJ Shin was present during the times noted above for observations relative to the work being performed.

Bay 1

This QA Inspector observed the following work in progress for Bay 1.

ZPMC was using the Shield Metal Arc Welding (SMAW) process.

ZPMC QC is identified as Wang Lian.

Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specification (WPS).

Listed below are the locations that were identified by this QA inspector

Components: Traveler Rail

PCMK: 20TR2-036-009

Welder: 054467

Report: B-WR20368

WPS-345-SMAW-1G (1F)-repair

PCMK: 20TR2-038-011

Welder: 053609

Report: B-WR20369

WPS-345-SMAW-1G (1F)-repair

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PCMK: 20TR-038-011

Welder: 053795

Report: B-WR17952

WPS-345-SMAW-1G (1F)-repair

Bay 3

ZPMC performed remove weld metal use Air Arc Gouging on deck drainage casting to cover plate weld. These 37 pieces of casting was out of dimension tolerance after machining and cover plate welded.

Bay 10

This QA Inspector observed the following work in progress for Bay 10.

ZPMC was using the Shield Metal Arc Welding (SMAW) process.

ZPMC QC is identified as Guo Yan Fei.

Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specification (WPS).

Listed below are the locations that were identified by this QA inspector

Components: Traveler Rail

PCMK: 20TR-030

Welder: 056364

Report: B-WR16928

WPS-345-SMAW-4G (4F)-repair

PCMK: 36TR1-2, 3, 8

Welder: 057220

WPS-B-P-2212-TC-U5b

Components: Bike Path

PCMK: BK15B-001-015~020

Welder: 040582

WPS-B-P-2211TC-U4C

PCMK: BK16B-001-015, 016, 017

Welder: 045581, 040365

WPS-B-P-2211TC-U4C

PCMK: BK8A18-001-112~115

Welder: 052493, 057258

WPS-B-P-2213-B-U2

PCMK: BK008A8-002

Welder: 053869

WPS-B-P-2313-TC-P4

PCMK: BK008A8-007

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Welder: 053829

WPS-B-P-2313-TC-P4

This QA Inspector observed the following work in progress for Bay 10.

ZPMC was using the Flux Core Arc Welding (FCAW) process.

ZPMC QC is identified as Guo Yan Fei.

Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specifications (WPS). Listed below are the locations that were identified by this QA inspector.

Components: Traveler Rail

PCMK: 31TR3-45, 46

Welder: 040367

WPS-B-T-2232-ESAB

PCMK: 28TR1-09, 12, 16

Welder: 054609

WPS-B-T-2232-ESAB

Heat straightening of PCMK, BK37E-001-112~115, under approved Heat Straightening procedure, HSR 1 (B)-10079, The in process temperature was at the time of this observation witnessed at less than 600°C. The ZPMC QC was identified as Guo Yan Fei. The approved HSR procedure stated that a maximum temperature of 600°C with 1-3 applications. The distortion that was previously measured and recorded on the HSR was Maximum 50~100mm.

Bay 11

This QA Inspector observed the following work in progress for Bay 11.

ZPMC was using the Shield Metal Arc Welding (SMAW) process.

ZPMC QC is identified as Mao Bin Bin.

Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specification (WPS). Listed below are the locations that were identified by this QA inspector

Components: Bike Path

PCMK: BK004A-059-MEP

Welder: 202319

WPS-B-P-2112, 2113

Trial Assembly Yard

This QA Inspector observed the following work in progress for Trial Assembly Yard.

ZPMC was using the Shield Metal Arc Welding (SMAW) process.

ZPMC QC is identified as Mao Bin Zhou Peng.

Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specification (WPS). Listed below are the locations that were identified by this QA inspector

Components: OBE 12

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PCMK: DP3011-001-013,018

Welder: 040270

WPS-B-T-4114-FCM-1

PCMK: DP3049-001-019, 020, 021

Welder: 202316

WPS-B-T-4114-FCM-1

PCMK: DP3049-001-022, 023, 024

Welder: 057333

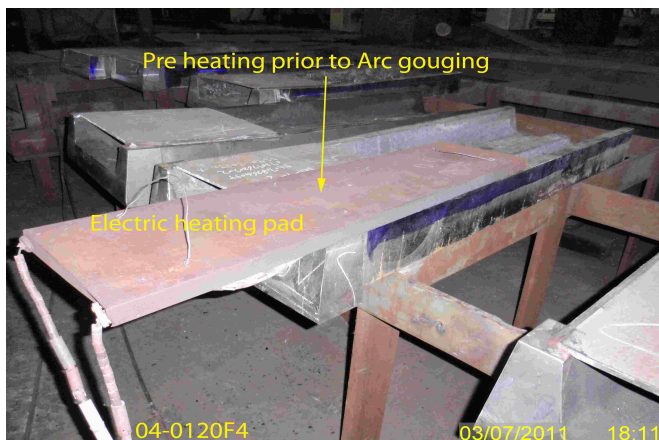
WPS-B-T-4114-FCM-1

PCMK: CB3001A-017-018

Welder: 044304

WPS-B-P-2212-TC-U4b-FCM-1

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



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Summary of Conversations:

No relevant conversations

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 15000422372, who represents the Office of Structural Materials for your project.

Inspected By:	Shin,DJ	Quality Assurance Inspector
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Reviewed By:	Riley,Ken	QA Reviewer
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